SETUP & OPERATION MANUAL

8" PARALLELOGRAM JOINTER

FEATURES

- Large surface, ground cast-iron tables for stability and added support when feeding longer stock.
- Large, heavy-duty center-mounted cast-iron fence with 45°, 90° and 135° positive stops.
- Precision four point parallelogram table adjustment system allows for easy parallel alignment of in-feed and out-feed table to the cutterhead and each other.
- Independent in-feed and out-feed table height adjustment handwheels.
- Heavy duty closed base stand for maximum stability.
- 4" dust collection port.
- Magnetic safety switch mounted above the in-feed table for quick, easy access.
- Includes 2 hand-paddle style push blocks with onboard storage mounts.
- Convenient front to back fence adjustment handwheel.
- With Magnum helical cutter dead. 4 rows - total 22 double-sided inserts

SPECIFICATIONS

TABLE SIZE
8 1/16" x 82 7/8" (206 x 2106 mm)

MAXIMUM CUTTING WIDTH
8" (203 mm)

MAXIMUM CUTTING DEPTH
1/2" (13 mm)

RABBETING CAPACITY
1/2" (13 mm)

FENCE SIZE
4 1/2" x 38 1/2" (114 x 978 mm)

CUTTER HEAD SPEED
5000 RPM

CUTTER HEAD TYPE
MAGNUM HELICAL

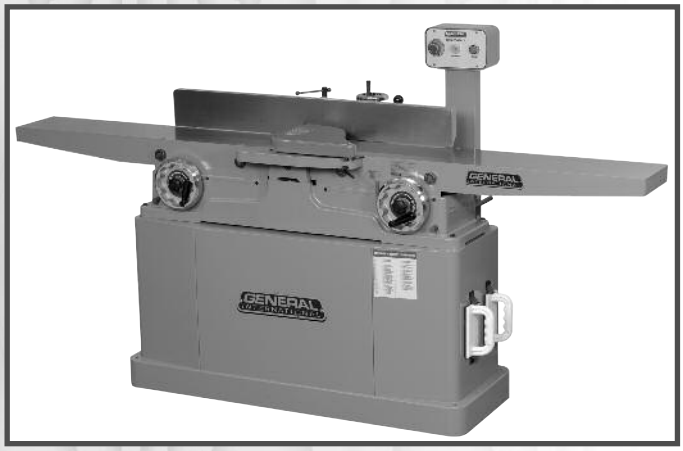
NUMBER OF INSERTS
4 ROWS – TOTAL 22 DOUBLE-SIDED INSERTS

BASE DIMENSIONS (L X W)
43 1/2" x 16" (1105 x 406 mm)

TABLE HEIGHT
31" (790 mm)

MOTOR
3 HP, 220 V, 1 PH, 13 A

WEIGHT
592 LBS (269 kg)



MODEL
#80-225HC MI

GENERAL
GENERAL INTERNATIONAL

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THANK YOU for choosing this General® International model 80-225HC 8" Parallelogram Jointer. This jointer has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this jointer as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of jointer and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International ® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate this jointer when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the jointer is in operation; do not permit them to operate the jointer.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector. Wear face, eye, ear, respiratory and body protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the jointer is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
9. Keep hands well away from knives and all moving parts. Use a push stick to feed stock, and a brush, not hands, to clear away chips and dust.
10. Be sure that the knives are securely installed in the cutterhead.
11. Always use clean, properly sharpened knives. Dirty or dull knives are unsafe and can lead to accidents.
12. If using a power feeder, stop the feeder before stopping the jointer.
13. Do not push or force stock into the cutter head. The jointer will perform better and more safely when working at the rate for which it was designed.
14. Be sure that the cutter head has gained full operating speed before starting to joint.
15. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning be sure it is properly re-attached before using the tool again.
17. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury.
18. Never stand on machinery. Serious injury could result if the tool is tipped over or if the cutting tool is unintentionally contacted.
19. Always disconnect the tool from the power source before servicing or changing accessories such as knives, or before performing any maintenance or cleaning, or if the machine will be left unattended.
20. Make sure that the switch is in the "OFF" position before plugging in the power cord.
21. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
22. Do not use this jointer for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.

Additional Safety Instructions for Jointers

Because each shop situation is unique, no list of safety guidelines can ever be complete. The most important safety feature of any shop is the knowledge and good judgement of the user. Use common sense and always keep safety considerations, as they apply to your individual shop conditions, first and foremost in mind. If you have any doubts about the safety of an operation you are about to perform: STOP! Do not perform the operation until you have validated from qualified individuals if the operation is safe to perform and what is the safest method to perform it.

1. WORK PIECE KICKBACK
Kickback is when the work piece is ejected at high speeds from the jointer table by the force of the cutter head. To minimize the risk of injury from kickback, always use push blocks and wear safety glasses. Do not operate this machine if you do not understand kickback, its causes and how to avoid it.

2. CUTTER HEAD ALIGNMENT
To reduce the risk of injury and to avoid kick-back, keep the top edge of the out-feed table aligned with the top dead center edge of the knife.

3. PUSH BLOCKS
Always use push blocks when jointing. Never pass your bare hands directly over the cutter head without a push block to hold and guide the workpiece.

4. WORKPIECE SUPPORT
To make safe cuts and reduce the risk of injury, support the workpiece adequately at all times. Never attempt to make a cut with an unstable workpiece.

5. KICKBACK ZONE
The kickback zone on a jointer is the area directly in the path through and off of the end of the in-feed table. Never stand or allow others to stand in this area during operation.

6. MAXIMUM DEPTH OF CUT
The maximum depth of cut for one pass is 1/8". Never attempt to remove more material than 1/8" in any single pass.

7. JOINTING WITH THE GRAIN
Jointing against the grain or jointing end grain is dangerous and could produce chatter or excessive chip out. Always joint with the grain.

8. KEEPING GUARDS IN PLACE
Except when rabbeting, all operations must be performed with the guard in place. After rabbeting, be sure to replace the guard.

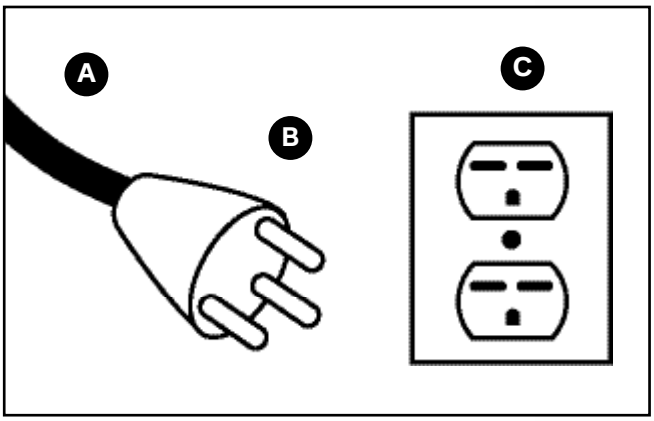
9. PROPER CUTTING
Always move the work piece over the cutter head from the in-feed table towards the out-feed table until the work piece has passed completely over the cutter head. Never back the work piece towards the in-feed table.

10. USING GOOD WORK PIECE STOCK
Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: Do Not Joint It.

ELECTRICAL REQUIREMENTS

BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.



ELECTRICAL CONNECTIONS

Both a manual circuit breaker (or similar device) as well as an electrical plug (similar to the one shown) are recommended and **should be installed by a qualified electrician**. Use locally approved wire that includes a separate grounding wire ⓐ, and a 3 prong grounding type plug ⓑ with a matching receptacle ⓒ.

GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock to the operator. The motor of this machine is wired for 220V single phase operationwired for 220V single phase operation. As with many stationary industrial type machines, because each installation situation is unique, this jointer is supplied without a power cord or plug. The installation of an appropriate power cord and plug must be performed by a qualified electrician. The machine must be connected to an electrical source using a power cord that has a grounding wire, which must also be properly connected to the grounding prong on the plug. The outlet must be properly installed and grounded and all electrical connections must be made in accordance with all local codes and regulations.

CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

The use of an extension cord is not generally recommended for 220V equipment. If you find it necessary, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

If you find it necessary to use an extension cord with your machine make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD

AMPERE RATING	TOTAL LENGTH OF CORD IN FEET				
	220 VOLTS	50 FEET	100 FEET	200 FEET	300 FEET
	AWG				
< 5	------->	18	16	16	14
6 TO 10	------->	18	16	14	12
10 TO 12	------->	16	16	14	12
12 TO 16	------->	14	12	* NR	* NR

* NR = Not Recommended

8” PARALLELOGRAM JOINTER
80-225HC

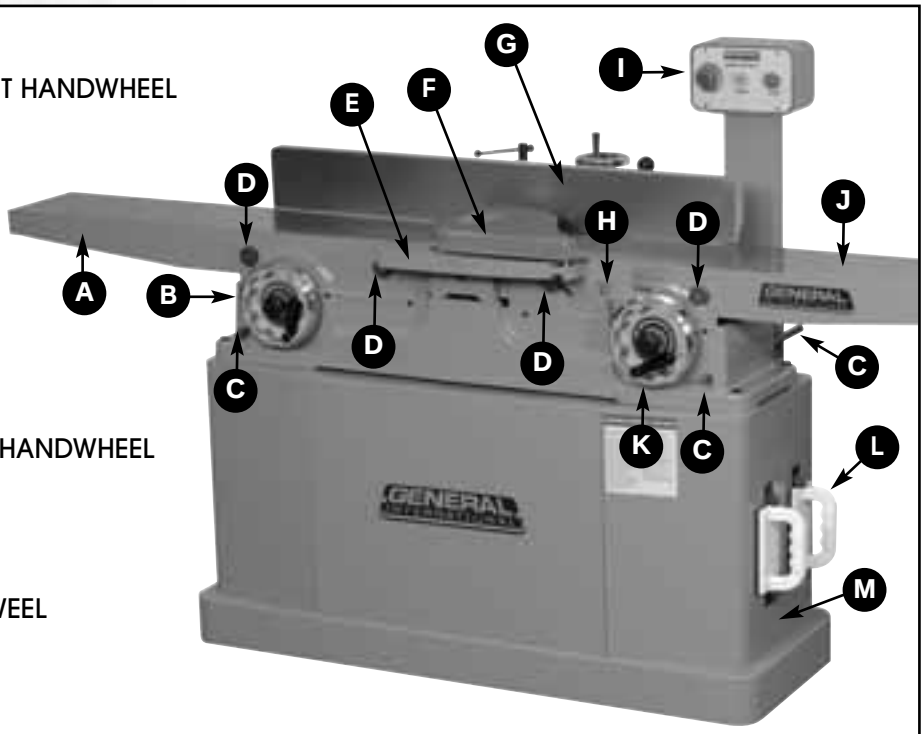
BASIC FUNCTIONS

This 8” jointer is designed for face and edge jointing in solid wood only. The unit is not designed nor should it be used to surface or prepare, plywood, wood panelling, particleboard, MDF nor any other wood based by-products nor any non-wood based materials.

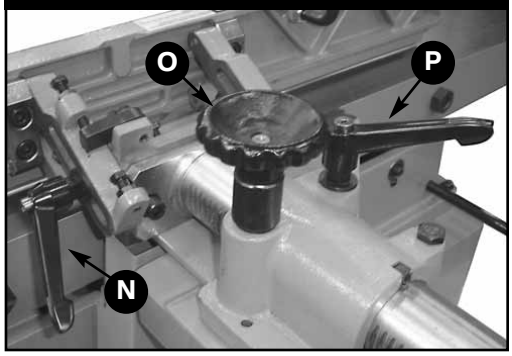
The 80-225HC 8” jointer features a precision four point parallelogram table adjustment system that allows for easy parallel alignment of in-feed and out-feed table to the cutterhead and each other. The unit is also equipped with our “Magnum” helical cutterhead with reversible carbide inserts.

IDENTIFICATION OF MAIN PARTS AND COMPONENTS

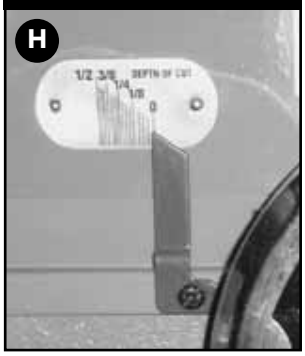
A- OUT-FEED TABLE
B- OUT-FEED TABLE ADJUSTMENT HANDWHEEL
C- LIFTING BAR
D- ECCENTRIC ADJUSTERS
E- RABBETING ARM
F- CUTTER HEAD GUARD
G- FENCE ASSEMBLY
H- DEPTH OF CUT INDICATOR
I- MAGNETIC SWITCH
J- IN-FEED TABLE
K- IN-FEED TABLE ADJUSTMENT HANDWHEEL
L- PUSH BLOCKS
M- BASE WITH MOTOR
N- FENCE TILT LOCKING LEVER
O- FENCE ADJUSTMENT HANDWEEL
P- FENCE LOCKING LEVER
Q- 1/2” DEPTH STOP BOLT
R- ZERO POINT STOP BOLT



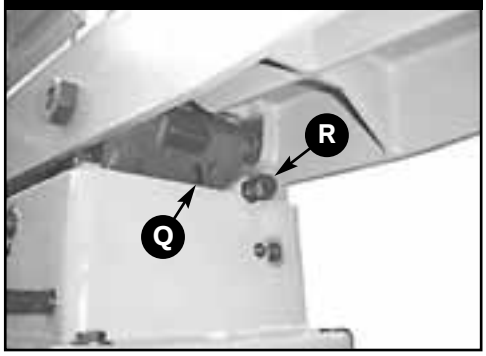
FENCE CONTROLS



DEPTH OF CUT INDICATOR



IN-FEED TABLE UNDERSIDE VIEW



UNPACKING

Carefully unpack and remove the unit and its components from its shipping crate and check for missing or damaged items as per the list of contents below.

NOTE: Please report any damaged or missing items to your GENERAL® INTERNATIONAL distributor immediately.

LIST OF CONTENTS — QTY

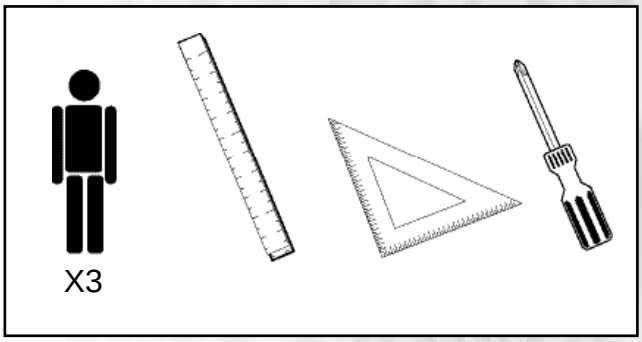
A - JOINTER 1
B - CUTTER HEAD GUARD 1
C - PUSH BLOCK 2
D - SCREWDRIVER 1
E - 11-13 MM OPEN END WRENCH 1
F - 17-19 MM OPEN END WRENCH 1
G - 4 MM ALLEN KEY 1
H - 5 MM ALLEN KEY 1
I - 6 MM ALLEN KEY 1
J - 8 MM ALLEN KEY 1

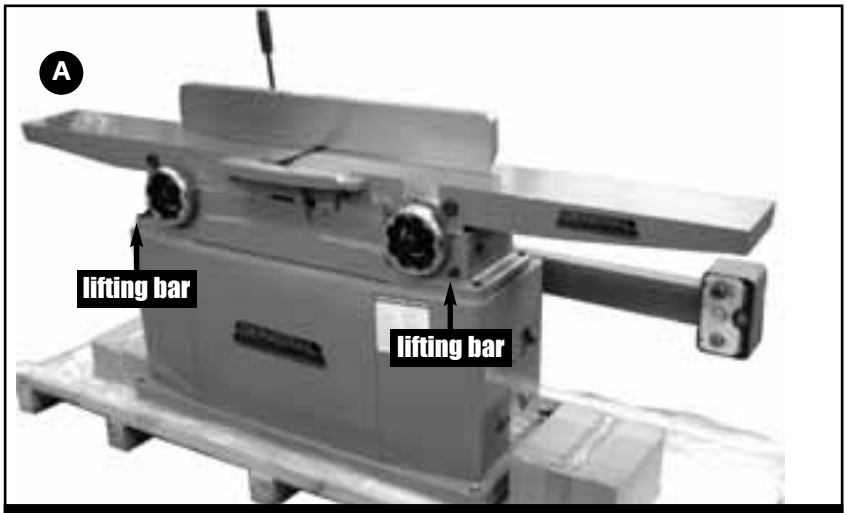
HELICAL CUTTER HEAD TOOLS/REPLACEMENT PARTS

K - 5 MM T ALLEN KEY 2
L - 5 MM ALLEN KEY 1
M - NUT 4
N - SCREW 4
O - KNIFE-HOLDER / CHIP-BREAKER 4
P - CARBIDE INSERT (STANDARD) 4

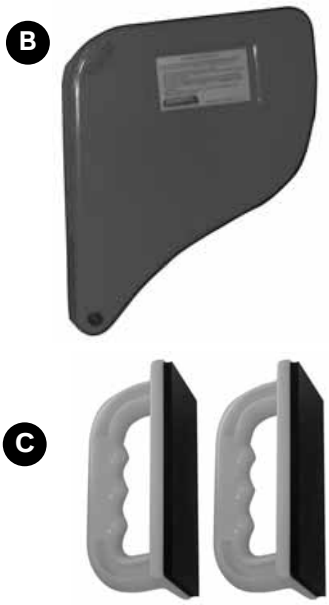
ADDITIONAL REQUIREMENTS FOR SET UP

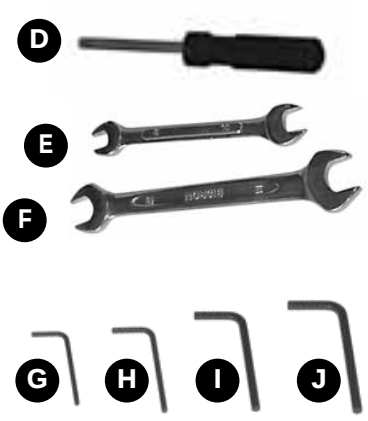
- 3 Extra people to assist with lifting
- Straightedge
- 45° & 90° combination square
- Phillips Screwdriver

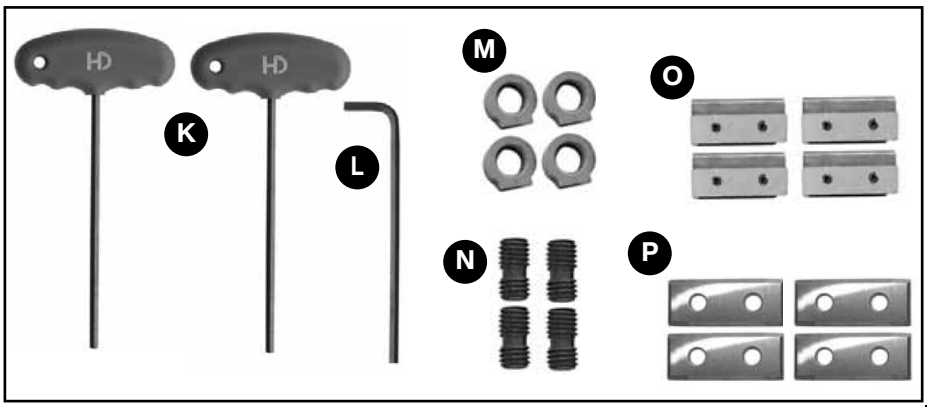




Important! To avoid disaligning the tables, never lift or move the jointer by it's tables when lifting. Always use the lifting bars to lift or move the jointer.







PREPARATION AND PLACEMENT WITHIN THE SHOP

CLEAN UP

The protective coating on the jointer tables prevents rust from forming during shipping and storage. Remove it by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.)

A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the saw's painted surfaces, as many solvent-based products will remove paint.

To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.

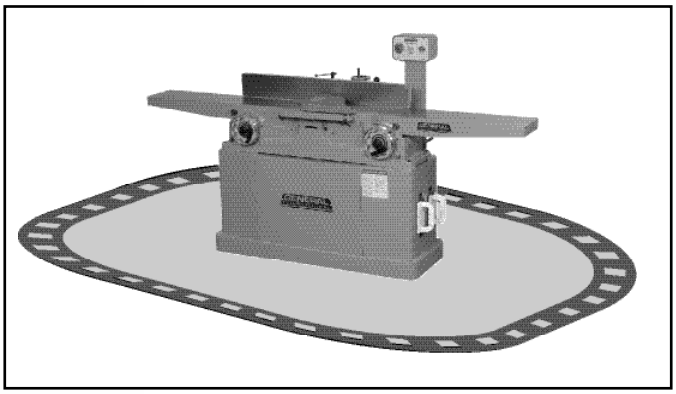
PLACEMENT WITHIN THE SHOP

THIS MODEL 80-225HC JOINTER IS VERY HEAVY – 592 LBS (269 KG). DO NOT OVER-EXERT. THE HELP OF OF AT LEAST THREE ASSISTANTS, A HOIST OR FORKLIFT WILL BE NEEDED FOR THE FOLLOWING STEP.

TO LIMIT THE RISK OF SERIOUS INJURY OR DAMAGE TO THE MACHINE, ANY EQUIPMENT USED TO LIFT THIS MACHINE (HOIST OR FORKLIFT) SHOULD HAVE A RATED CAPACITY IN EXCESS OF 592 LBS - 269 KG.

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the jointer and the operator.

Plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic (either passing shop visitors or other shop workers) or other tools or machinery.



ESTABLISHING A SAFETY ZONE

For shops with frequent visitors or multiple operators, it is advisable to establish a safety zone around shop machinery. A clearly defined "no-go" zone on the floor around each machine can help avoid accidents that could cause injury to either the operator or the shop visitor. It is advisable to take a few moments to either paint (using non-slip paint) or using tape, define on the floor the limits or perimeter of each machines safety zone. Take steps to ensure that all operators and shop visitors are aware that these areas are off limits whenever a machine is running for everyone but the individual operating the unit.

ASSEMBLY INSTRUCTIONS

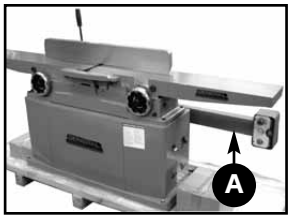
For your convenience this jointer is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.

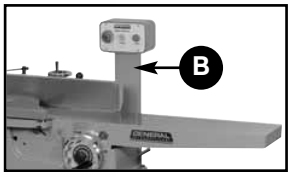
SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

REPOSITION THE SWITCH POST

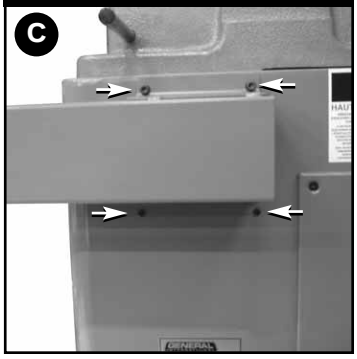
To limit the potential for damage in transport, this jointer is shipped from the factory with the switch post in the horizontal position **A**. The switch post must be repositioned in the vertical position **B**.

1. Remove the 4 cap screws and flat washers **C** that secure the post to rear of the jointer base.
2. Reposition the switch post in the vertical position and secure in place with the 4 cap screws and flat washers **B**.

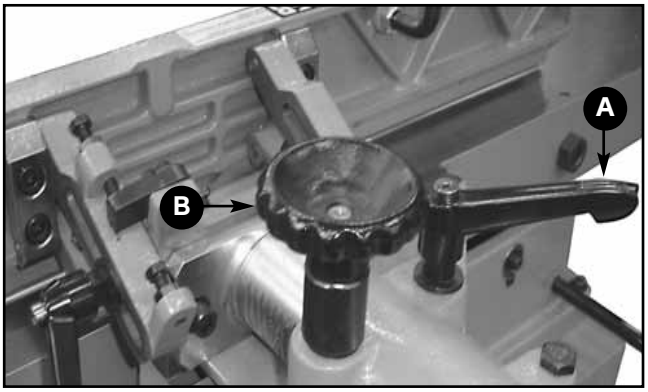




REAR VIEW



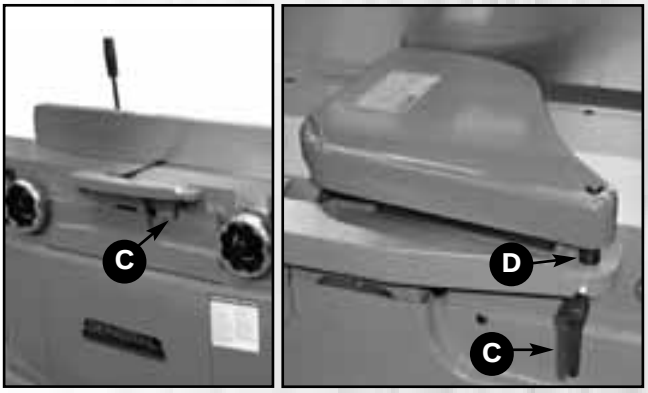
INSTALL THE CUTTER HEAD GUARD



The cutter head guard is designed to automatically snap back against the fence and cover the knives once the workpiece has cleared the guard.

To install the guard:

1. To give yourself unimpeded access to the cutter head, loosen the fence locking handle **A**, then use handwheel **B** to move the fence backwards, out of the way.

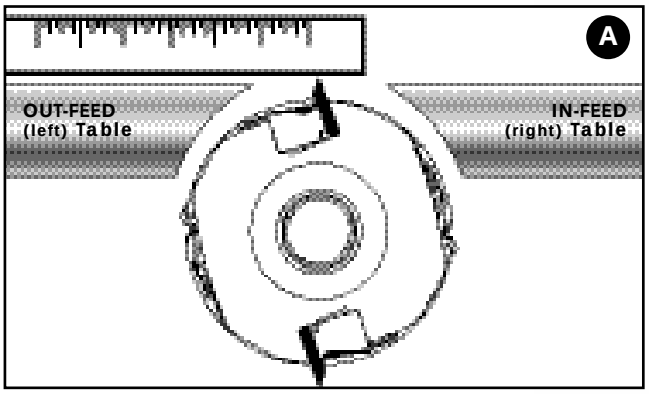


2. Loosen locking handle **C** on the rabbeting arm at the front of the jointer.
3. Fit the shaft of the cutter head guard as far as it will go down into the mounting hole **D**.
4. Adjust the positioning of the guard so that it completely covers the cutter head.
5. Tighten locking handle **C** to secure the cutter head guard in position.

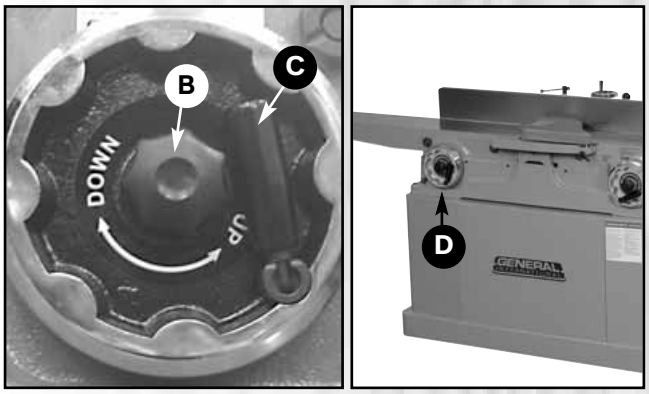
ADJUSTING AND SETTING THE OUT-FEED TABLE HEIGHT

The out-feed table should be set level with the highest point of the knives **A**. The height of the out-feed table should be verified and ajusted prior to first use. It should also be verified and re-adjusted periodically to compensate for knife wear and also upon knife replacement.

ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.



1. Make sure that the the machine is disconnected from the power source.
2. To give yourself unimpeded access to the cutter head and upper pulley, remove the cutter head guard and move the fence backwards, out of the way.
3. Set a straightedge onto the out-feed table so that it sits over the cutter head but does not completely cross the gap between the tables and touch the in-feed table **A**.
4. Turn the upper pulley by hand until any one of the knives is at it's highest point.



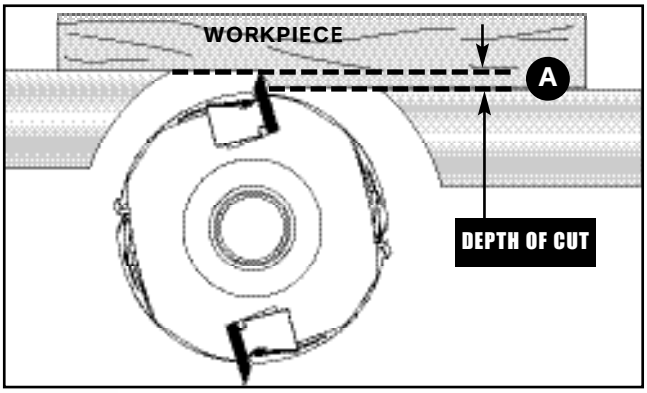
5. Loosen out-feed (left) table adjustment handwheel lock knob **B**.
6. Flip handle **C** down then use left handwheel **D** to adjust the out-feed table height so that the knife **barely touches** the straightedge.
7. Flip handle **C** up to allow you to minimize the obstruction the handwheel may cause during jointing operations.
8. Re-tighten lock knob **B** to secure the out-feed table in position.

ADJUSTING AND SETTING THE IN-FEED TABLE HEIGHT / DEPTH OF CUT

The depth of cut **A** is set by raising or lowering the in-feed table. Refer to the recommended depth of cut settings in section "Basic Jointing Operations Instructions", on page 16.

THE MAXIMUM DEPTH OF CUT FOR ONE PASS IS 1/8". NEVER ATTEMPT TO REMOVE MORE MATERIAL THAN 1/8" IN ANY SINGLE PASS.

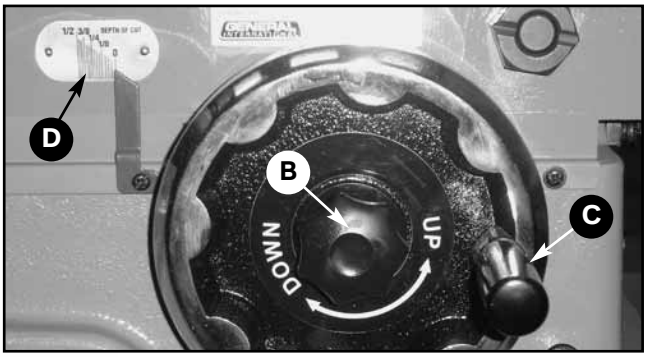
ALWAYS DISCONNECT THE MACHINE FROM THE POWER SOURCE BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.



1. Loosen the in-feed (right) table adjustment handwheel lock knob **B**.
2. Flip handle **C** down then use right handwheel to adjust the in-feed table height to the desired depth of cut.

Note: Refer to the graduated depth scale D .

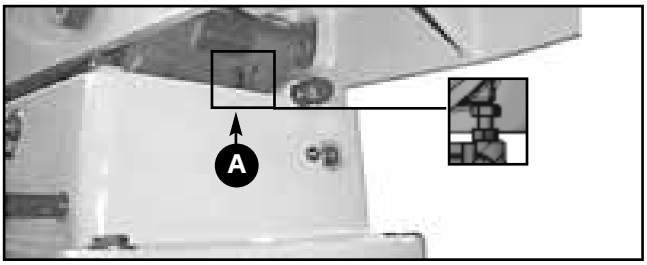
3. Flip handle **C** up to allow you to minimize the obstruction the handwheel may cause during jointing operations.
4. Re-tighten lock knob **B** to secure the in-feed table in position.



1/2" DEPTH STOP BOLT

As a time saving convenience, the 1/2" depth stop bolt **A** located under the in-feed table limits the downward travel of the in-feed table for faster in-feed table height adjustments.

Note: Check and, if needed, readjust the 1/2" depth stop bolt after making any table alignment adjustments.

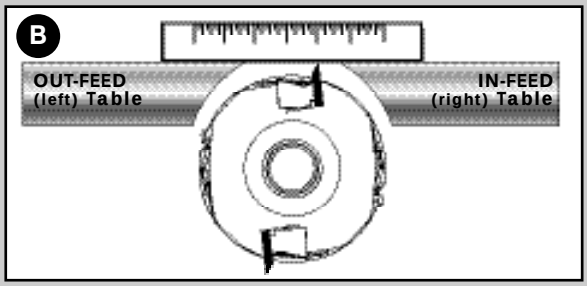


NOTE

PARALLEL ALIGNMENT OF THE IN-FEED AND OUT-FEED TABLE TO THE CUTTER HEAD AND BETWEEN EACH OTHER

The out-feed table and in-feed table have been factory set parallel to the cutterhead and with each other **B**.

However with use and vibration over time, it may eventually become necessary to re-align the tables. Refer to the instructions in section "Maintenance", on page 19 to 21 of this manual.

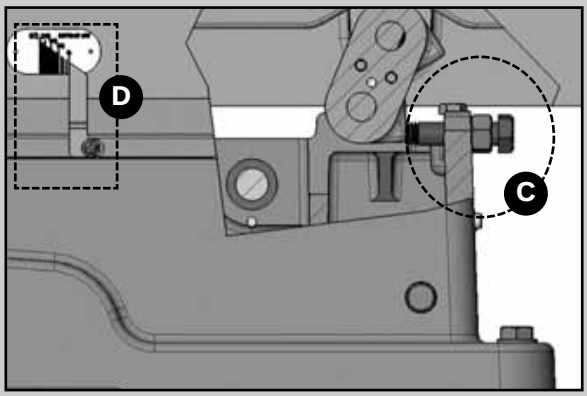


CHECKING / ADJUSTING THE ZERO POINT STOP BOLT & THE DEPTH OF CUT INDICATOR

The "Zero point stop bolt" **C** has been factory set to prevent the in-feed table from being raised above the maximum height of the cutter head.

The "Depth of cut indicator" **D** has been factory set to read "0" when the in-feed table is at the exact same height as the highest point of the cutter head.

However with use and vibration over time, it may eventually become necessary to re-adjust the "Zero point stop bolt" and "Depth of cut indicator". Refer to the instructions in section "Maintenance", on page 21 of this manual.



ADJUSTING THE FENCE & CHECKING / SETTING THE FENCE STOPS

The fence stops allow you to position the fence at specific pre-set angles in relation to the tables without having to measure each time you return to that angle.

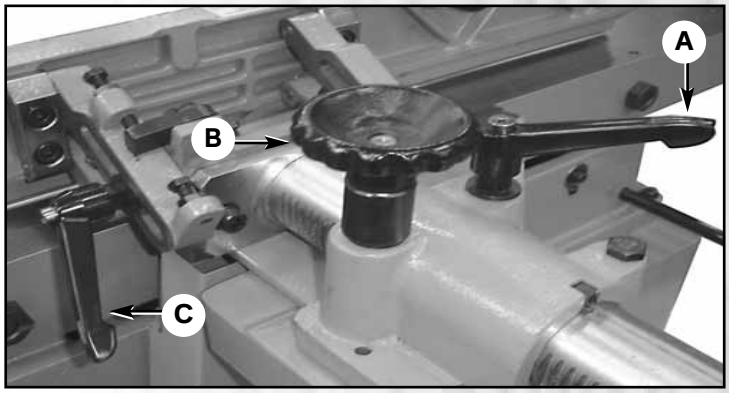
Due to wear and vibration, fence stops can over time become misaligned and should be checked periodically and re-set if necessary.

<u>To move the fence front to back:</u>

1. Loosen locking lever **A**.
2. Position the fence over the cutter head as needed using handwheel **B**.
3. Re-tighten locking lever **A**.

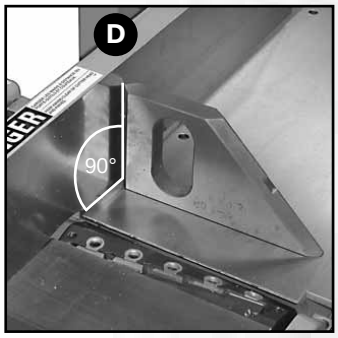
<u>To tilt the fence:</u>

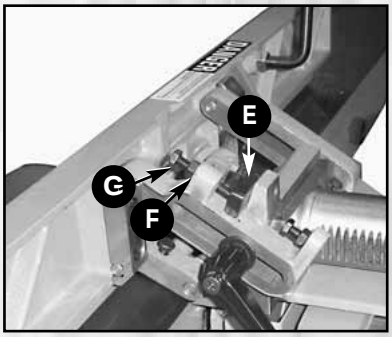
1. Loosen locking lever **C**.
2. Set the fence 45° inward or 45° inward
3. Re-tighten locking lever **C**.



<u>To set the **90°** fence stop:</u>

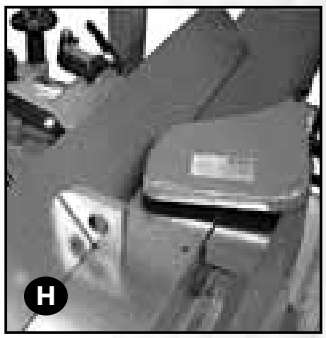
1. Using a 90° combination or machinists square, set the fence to 90° **D**.
2. Flip the 90° stop into position **E**.
3. Loosen the jam nut **F** on the 90° fence stop bolt.
4. Adjust the 90° fence stop bolt **G** until it makes contact with the 90° stop **E**.
5. Retighten the jam nut **F**.

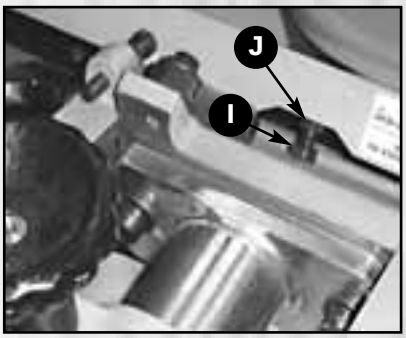




<u>To set the **45° outward** fence stop:</u>

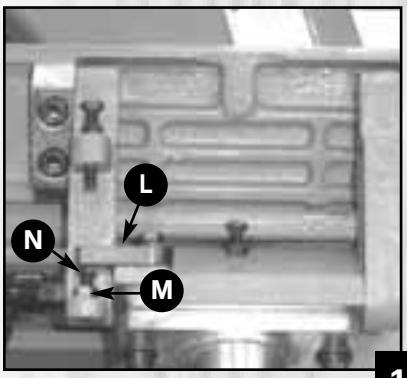
1. Using a combination or machinists square, set the fence to 45° outward **H**.
2. Loosen the jam nut **I** on the 45° outward fence stop bolt.
3. Adjust the 45° outward fence stop bolt **J** until it makes contact with the back of the fence.
4. Retighten the jam nut **I**.





<u>To set the **45° inward** fence stop:</u>

1. Using a 45° combination or machinists square, set the fence to 45° inward **K**.
2. Flip the 90° stop into position **L**.
3. Loosen the jam nut **M**.
4. Adjust the 45° inward fence stop bolt **N** until it makes contact with the back of the stop **L**.
5. Retighten the jam nut **M**.



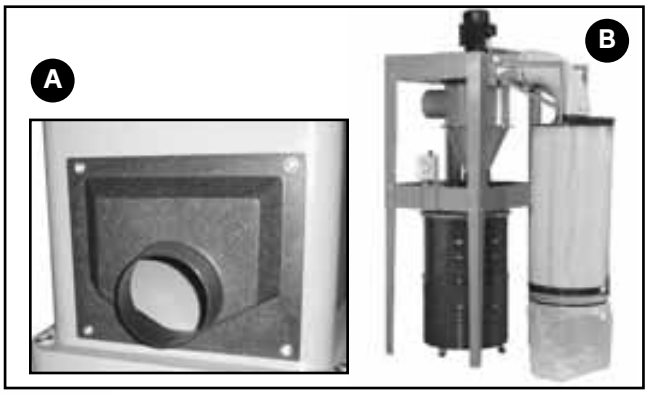
OPERATING INSTRUCTIONS

CONNECTING TO A DUST COLLECTOR

A dust port with a 4" opening **A** is provided to accommodate connection to a dust collector **B** (not included).

Be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at www.general.ca.

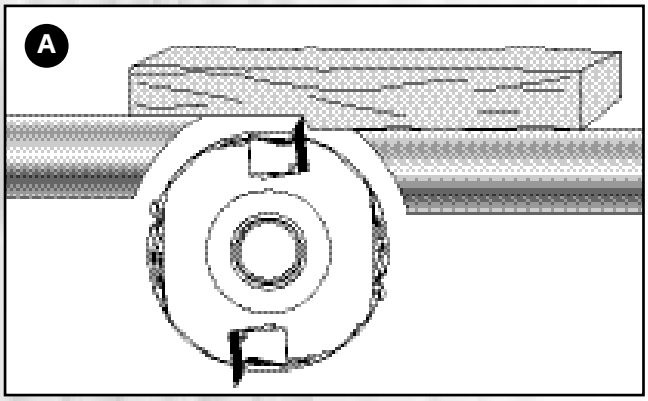


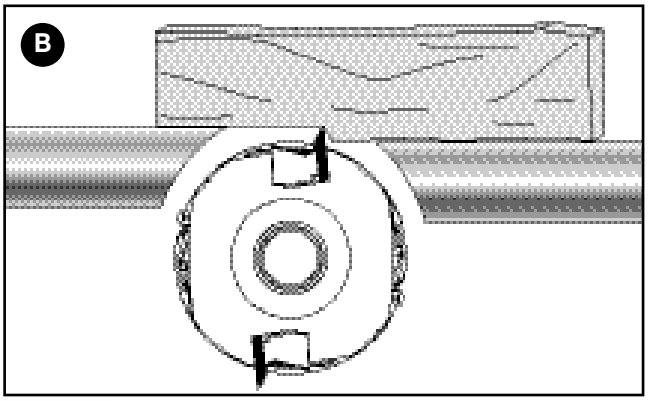
BASIC PRINCIPLES OF JOINTING

This jointer is designed to remove material from the bottom face of a board in order to bring one face of the board (or a series of boards) perfectly flat **A**.

This perfectly flat face is then placed against the fence, set at 90° to the tables, to obtain a perfectly perpendicular 90° flat edge **B**.

This jointer is not intended (and should not be used) to joint any material other than solid wood.

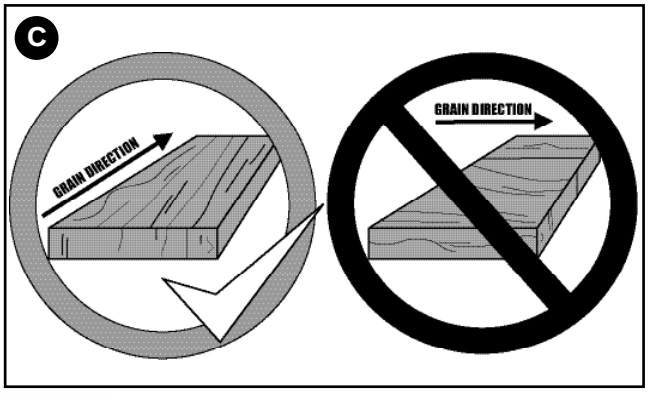




SELECTING BOARDS SUITABLE FOR JOINTING

1. Jointing safety begins with the stock used with the machine. Inspect the work piece carefully before jointing it. Never joint a board that has loose knots, staples, nails or other embedded foreign objects. If you have the slightest doubt about the structural integrity or stability of a board: **Do Not Joint It.**

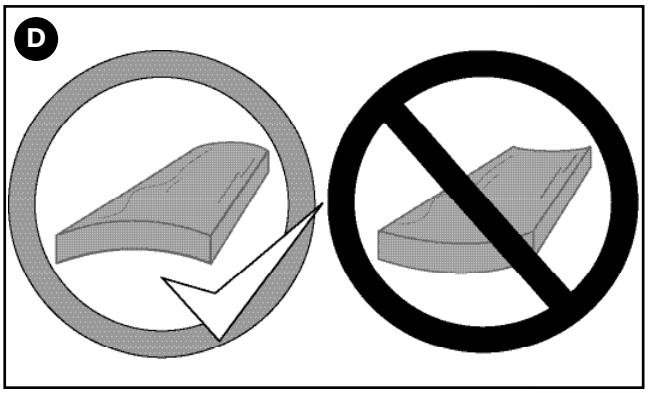
2. Only boards with the grain running more or less lengthwise are suitable for jointing **C**.

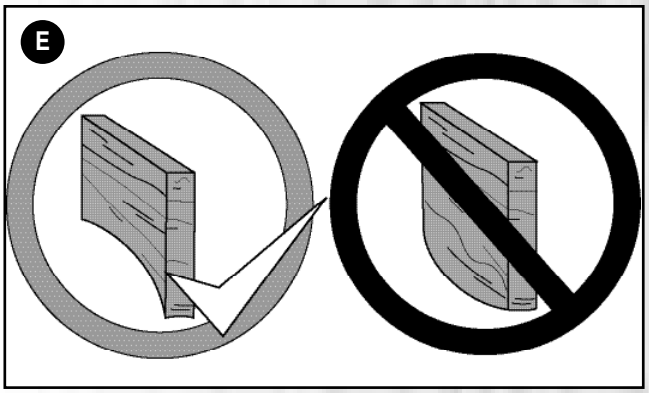


ALWAYS JOINT IN THE GENERAL DIRECTION OF THE GRAIN. JOINTING AGAINST THE GRAIN OR JOINTING END GRAIN IS DANGEROUS AND MAY CAUSE THE WORKPIECE TO SHATTER.

DETERMINE THE CONCAVE FACE AND EDGE OF YOUR BOARD

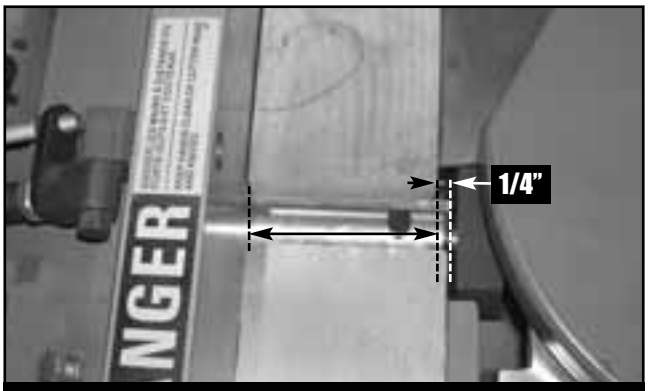
Place your board on a flat surface to identify its concave face **D** and edge **E.** The boards must be jointed with its concave face and edge against the jointer table.



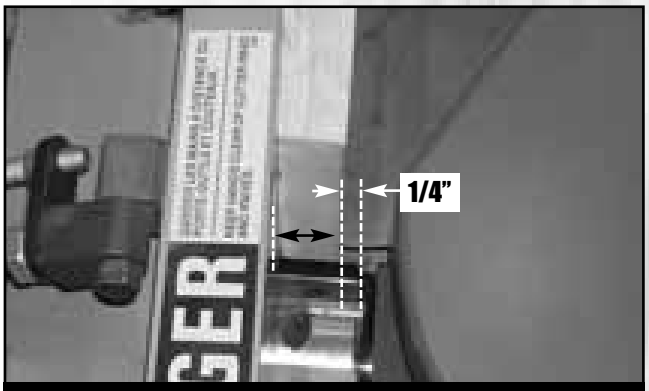


ADJUST FENCE FRONT TO BACK POSITION

To limit your exposure to the knives in the cutter head, never take more knive length than is required to complete the cut. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.



FACE JOINTING



EDGE JOINTING

CHECKLIST BEFORE STARTING

VERIFY ALL CHECK POINTS BEFORE STARTING. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

- Make sure you and any assistants are wearing safe appropriate workshop attire. Roll up long sleeves, secure long hair and remove any jewelry: watches, rings, bracelets or anything that could become caught in the moving parts, potentially causing serious injury.
- Make sure the board has been inspected and is suitable for jointing as explained in the previous section "Selecting boards suitable for jointing".
- Verify that the cutter head guard is functioning properly (snaps back against the fence and covers the knives).
- Make sure that the fence is properly set and locked in place.
- Make sure to have on safety glasses as well as hearing and respiratory protection at all times when using the jointer.

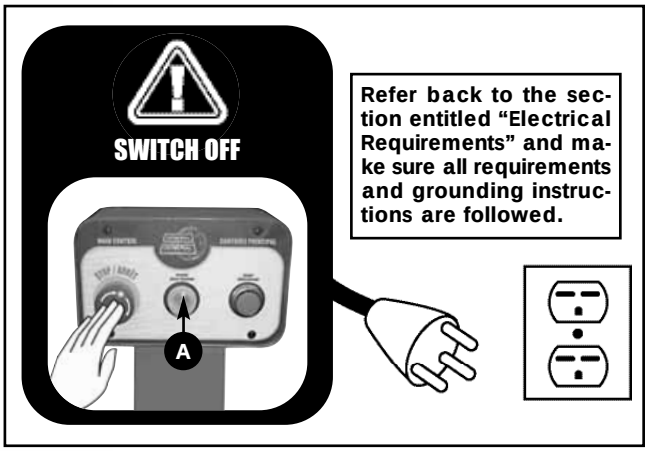
CONNECTING TO A POWER SOURCE

TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

Once the assembly and adjustment steps have been completed, uncoil the power cord and plug it into an appropriate outlet. The Power-on indicator light **A** will illuminate.

When jointing operations have been completed unplug the jointer from the power source.


SWITCH OFF
A
Refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed.

MAGNETIC SAFETY SWITCH

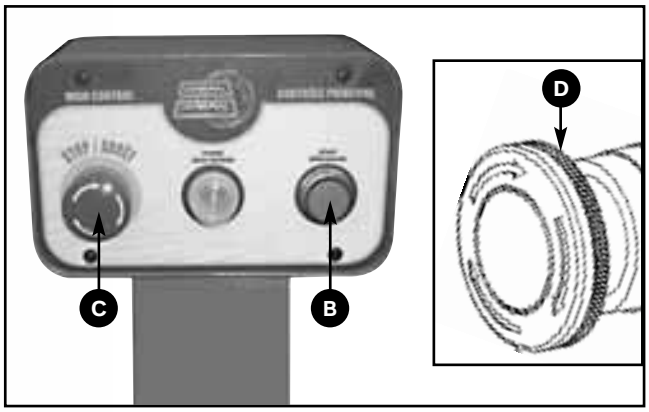
This model 80-225HC jointer is equiped with a MAGNETIC SAFETY SWITCH mounted above the in-feed table for quick, easy access, and designed to protect the unit and the user from power surges, power outages and unwanted or unintentional start-up.

To start the jointer:

Push on the green "START" button **B**. Wait for the cutter head to reach full speed before starting jointing.

To stop the jointer:

Push on the RED "STOP" button **C** and wait for the cutter head to come to a complete stop.



Once the RED "STOP" button has been pressed, the machine can only be started by turning the inner part of the button D to the right to release the stop button.

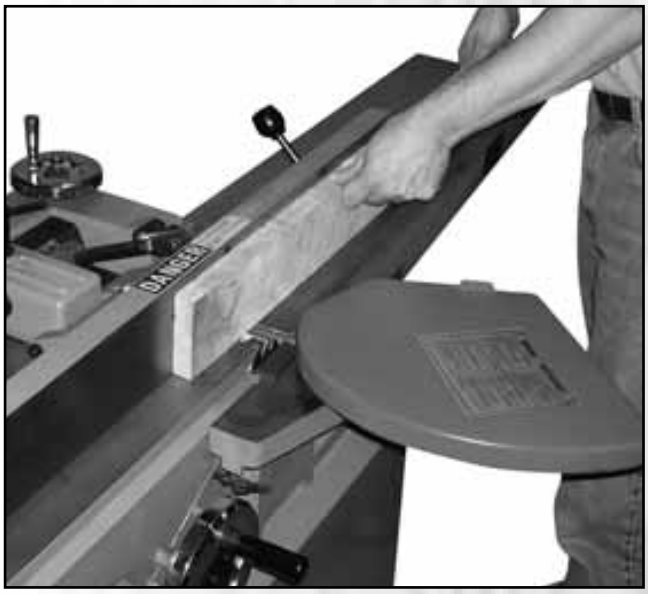
BASIC JOINTING OPERATIONS

SURFACE PLANING

1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/32" is recommended for face planing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°.
4. If your workpiece is cupped, place the cupped side face down on the in-feed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine & using push blocks press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.

FAILURE TO USE PUSH BLOCKS WHEN SURFACE PLANING MAY RESULT IN SERIOUS PERSONAL INJURY. ALWAYS USE PUSH BLOCKS TO HELP KEEP YOUR HANDS AT A SAFE DISTANCE FROM THE KNIVES WHEN SURFACE PLANING.

EDGE JOINTING



1. Inspect the stock before starting & remove any foreign objects or debris.
2. Set the depth of cut as required (1/16" - 1/8" is recommended for edge jointing - Less for hard wood or wider stock.)
3. Set & lock the fence at 90°
4. If your workpiece is cupped, place the cupped side face down on the in-feed (right) table.
5. Set the position of the fence so that the length of blade remaining exposed is roughly 1/4" longer than the width of the board to be jointed.
6. Turn on the machine, press the stock against the table and tight to the fence, feeding the stock over the cutter head.
7. Inspect the board & repeat the steps if needed until the surface is flat.

RABBETING

1. Remove the blade guard & move the fence forward leaving only the width of the desired rabbet on the tables uncovered by the fence & lock the fence in position.

REMOVE THE BLADE GUARD FOR RABBETING ONLY. IMMEDIATELY REPLACE THE BLADE GUARD WHEN FINISHED. DO NOT PERFORM ANY OTHER JOINTING OPERATION WITH THE BLADE GUARD REMOVED. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

2. Inspect the stock before starting & remove any foreign objects or debris.
3. Set the depth of cut as required (1/16" - 1/8" is recommended for rabbeting - Less for hard wood or wider stock.)
4. Turn on the machine & using push blocks press the stock against the tables rabbeting arm and tight to the fence, feeding the stock over the cutter head.
5. Repeat the steps until the rabbet is cut to desired depth.

MAINTENANCE

MAKE SURE THE JOINTER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.

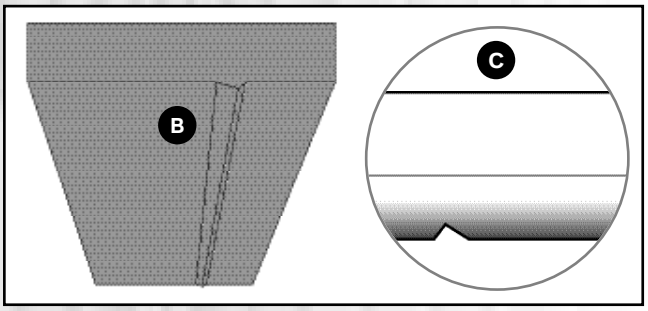
INSPECTING/REPLACING CUTTER HEAD KNIVES

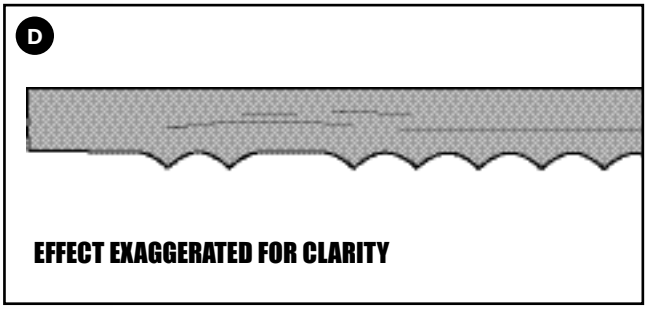
There are 22 reversible carbide inserts (knives) installed in the helical cutter head at the factory. With usage and normal wear over time, it will eventually become necessary to reverse and/or replace the inserts. To maintain even insert wear always reverse or replace all 22 inserts each time knife replacement is required.

When needed, replacement inserts **A** can be ordered through your local General International distributor under part #30-443.

Observing jointed workpieces as they come off of the machine and looking for signs of knife damage or wear is the best method to help you to determine when knives are due to be changed.

Signs to look for include:





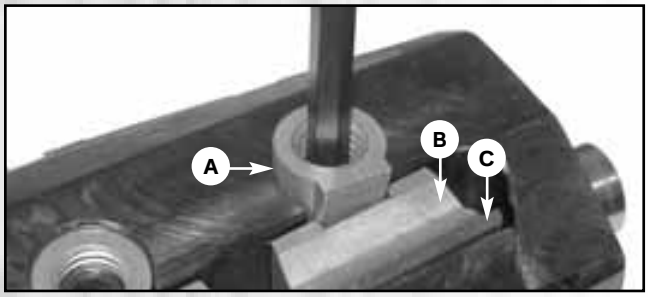
1. A raised ridgeline in the workpiece that runs a straight line from beginning to end of the board **B**. This is generally an indication that one or more knives has been nicked or damaged **C** by a foreign object such as a nail, staple or other hard object hidden or embedded in the workpiece.
2. A slight washboard or chatter effect **D** which can be an indication of uneven knife wear causing one knife to cut slightly deeper than the others.
3. Rough, irregular, torn or fuzzy grain on a freshly jointed surface may be a sign of worn or dull blades causing the wood to tear out. Sharp blades cut crisply and leave a relatively smooth finish.

Note: Fuzzy grain can also be a sign of high moisture content in the workpiece. If knives have recently been changed or if you suspect that moisture content and not dull knives is the cause, set the workpiece aside and test by jointing other boards with known or acceptable moisture content. If the jointed results using a different workpiece are smooth, then moisture content in your wood is the problem - no adjustments can be made to the machine for this. Set the "wet" stock aside and simply work with drier wood.

HELICAL CUTTER HEAD INSERT REVERSAL / REPLACEMENT

INSERT EDGES ARE VERY SHARP. USE CARE WHEN HANDLING INSERTS.

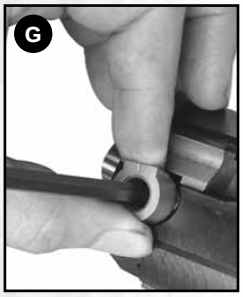
MAKE SURE THE JOINTER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS PERSONAL INJURY.



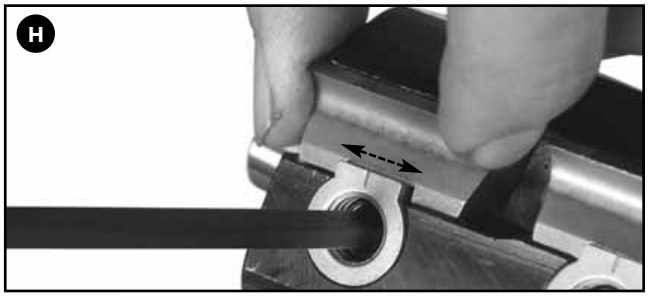
1. Using the one of the supplied long Allen keys, loosen but do not remove the nut and screw **A** and remove the knife-holder/chip breaker **B** and insert **C**.

2. Thoroughly clean the housing **D** before reinstalling a knife-holder/chip breaker and insert.

Important! To prevent knife height discrepencies, the knife holders / chip breakers and inserts must be clean and free of debris.



3. Thoroughly clean the knife-holders/chip breakers **E** and inserts **F** using a lacquer thinner and small brush.
4. Reverse or replace the insert and re-install it along with the knife-holder/chip breaker into the slot, then partially retighten the nut and screw **G**.



5. Center the knife-holder/chip breaker with the flat edge of the nut **H** and fully tighten the nut and screw.
6. Repeat with all other inserts.

Important! The nut and screw that secures the knife-holder/chip breakers and inserts in the cutter head does not have to be removed for blade reversal/replacement, only loosened. If the nuts and screws have to be replaced or if they have been removed instead of loosened, follow the instructions below to make sure that the knife-holder/chip breakers are all secured at the same height into the cutter head.

1. Place the screw in the threaded hole but don't start tightening it yet.

2. Place the nut on top of the screw but don't start tightening the screw yet.

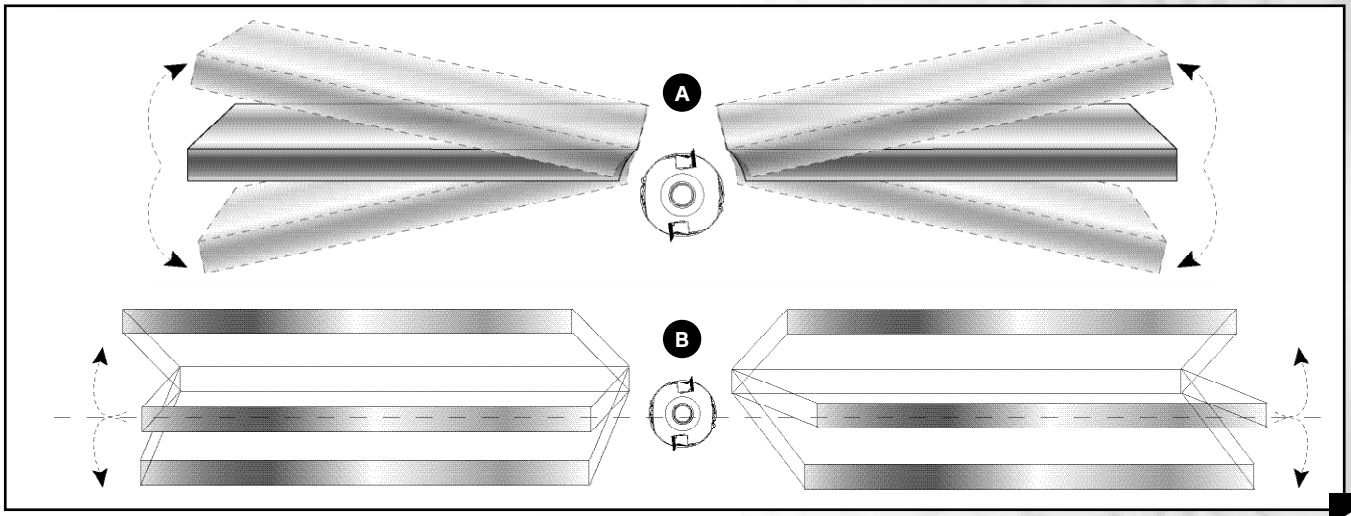
3. Holding the nut with your fingers, tighten the screw. This will tighten both the screw and nut simultaneously.

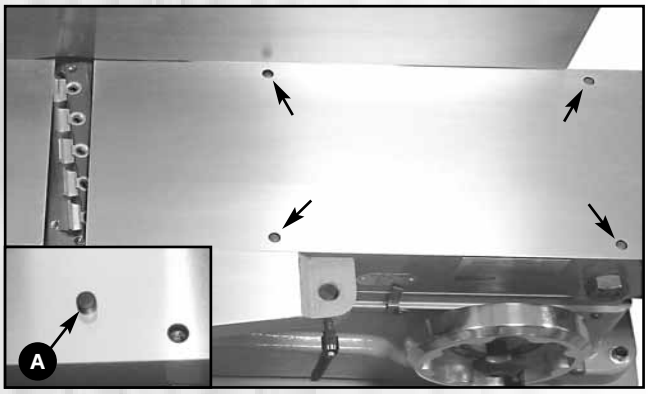
Do not thread the nut onto the screw before tightening the screw into the threaded hole in the cutter head.

PARALLEL (CO-PLANAR) ALIGNMENT OF THE IN-FEED AND OUT-FEED TABLES

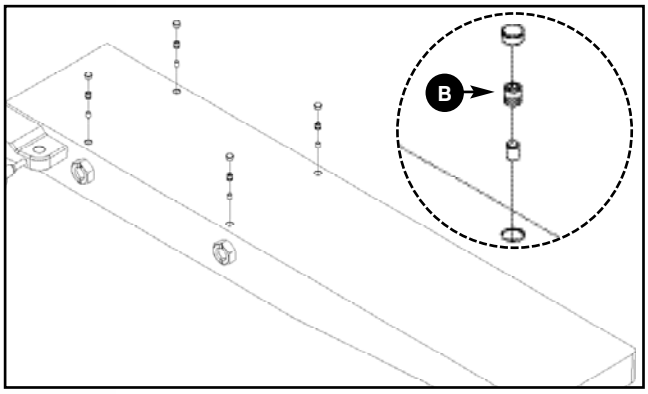
In order to obtain precision jointing results it is essential that the in-feed and out-feed tables are aligned parallel (co-planar) to each other at all times. If the end of one or both tables is tilted higher or sags lower **A**, or if either table tilts inward or outward out of parallel with the other **B**, this will result in jointed workpieces that are not flat or that cannot be face and then edge jointed to achieve a perfect 90° angle.

To facilitate precision table alignment this 80-225HC jointer features a parallelogram style 4-point adjustment system on each table. In order to achieve perfect alignment, the tables should be verified at the front (closest to the operator), back (closest to the fence) and across both diagonals (corner to corner) using a precision straightedge, preferably one that is as long as the two tables.

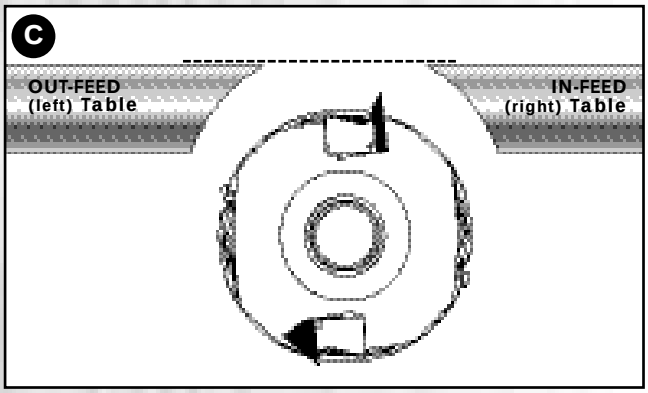




1. Disconnect the machine from the power source.
2. Remove the 4 rubber plugs **A** on both tables.

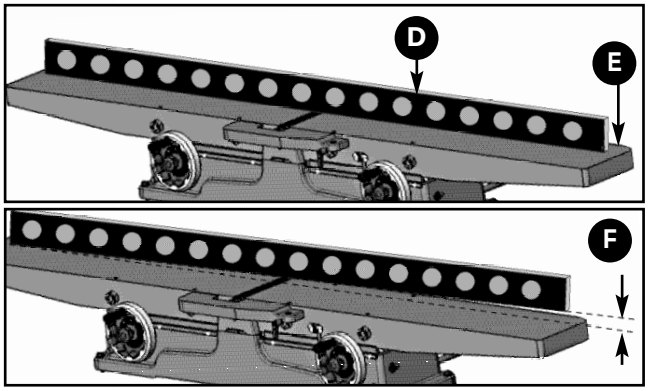


3. Using the supplied 4 Allen key, loosen the 4 locking screws **B** located under rubber plugs, 1 1/2 or 2 turns each.

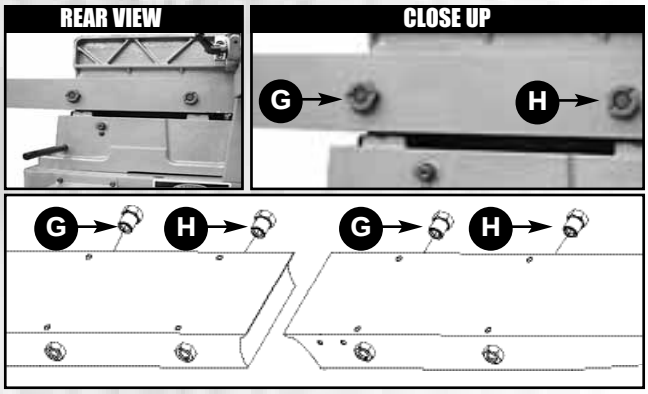


Note: Remove the cutter head guard and move the fence backwards, out of the way.

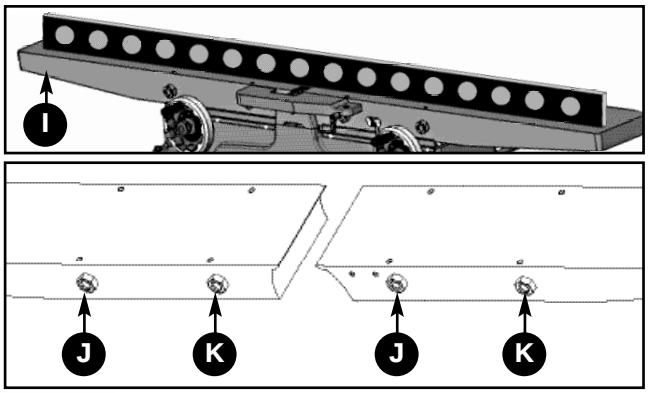
4. Raise the out-feed table higher than the cutter head then set the in-feed table at the same height as the out-feed table **C**.



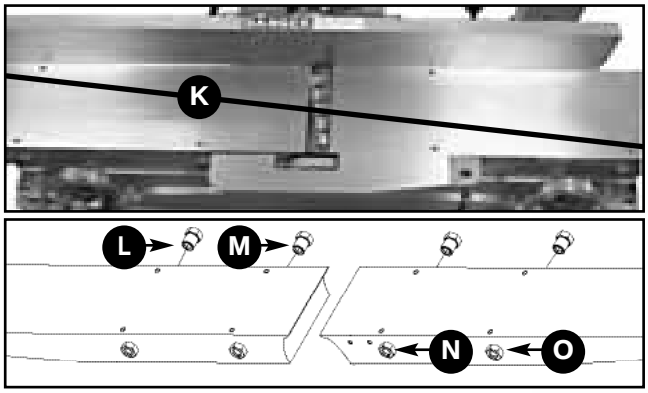
5. Set the precision straightedge **D** onto the out-feed and in-feed tables (near the rear edge **E** of the tables) and check for a gap between the straightedge and the tables **F**.



6. Use the supplied 17-19 mm open wrench to adjust the two eccentric adjusters **G** and **H** located on the rear edge of either/both tables to eliminate the gap between the table(s) and the straightedge.

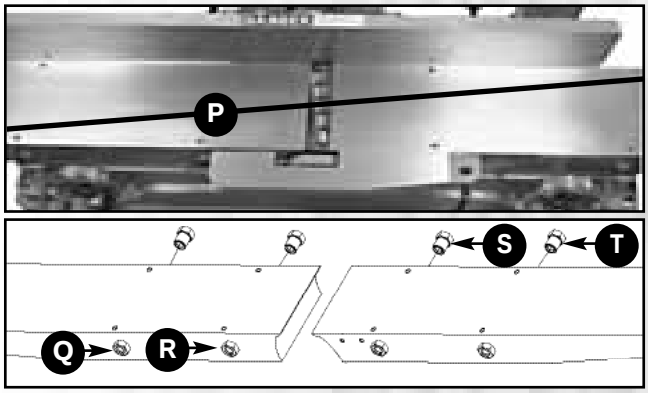


7. Set the straightedge near the front edge **I** of the tables.
8. Adjust the two eccentric adjusters **J** and **K** located on the front edge of either/both tables to eliminate the gap between the table(s) and the straightedge.



9. Set the straightedge onto the tables diagonally (corner to corner) as shown , **K**, and check for a gap between the straightedge and the tables.

10. If needed, adjust the two eccentric adjusters **L** and **M** located on the rear edge of the out-feed table and/or **N** and **O** located on the front edge of the in-feed table to eliminate the gap between the table(s) and the straightedge.



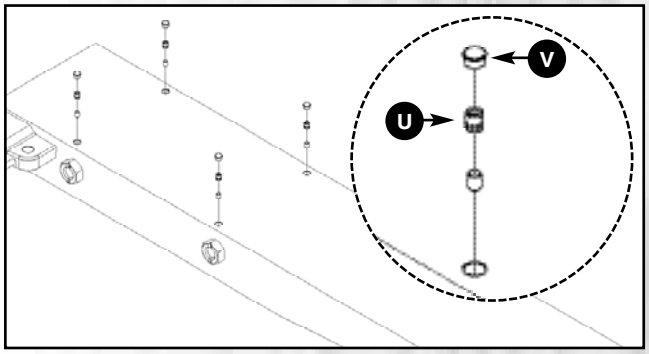
11. Set the straightedge onto the tables in the opposite diagonal position (as shown), **P**, and check for a gap between the straightedge and the tables.

12. If needed, adjust the two eccentric adjusters **Q** and **R** located on the front edge of the out-feed table and/or **S** and **T** located on the rear edge of in-feed table to eliminate the gap between the table(s) and the straightedge.

13. Repeat the previous steps as needed until alignment has been achieved.

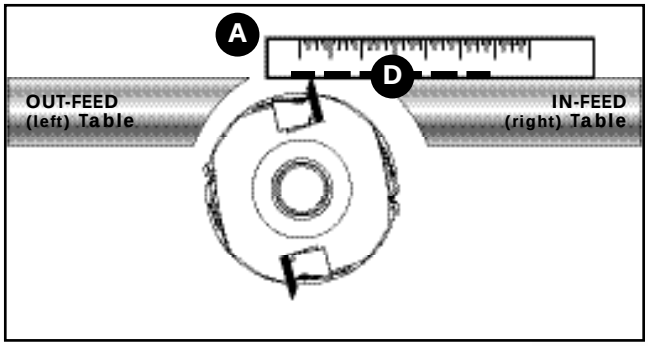
14. With the out-feed and in-feed tables coplanar, tighten the 4 locking screws **U** on both tables.

15. Re-install the 4 rubber plugs **V** on both tables.



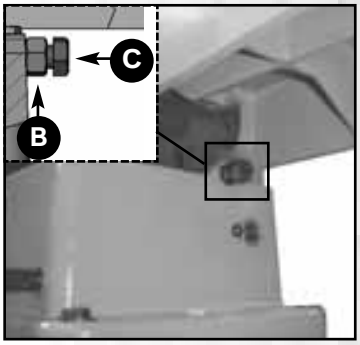
CHECKING / ADJUSTING THE ZERO POINT STOP BOLT & THE DEPTH OF CUT INDICATOR

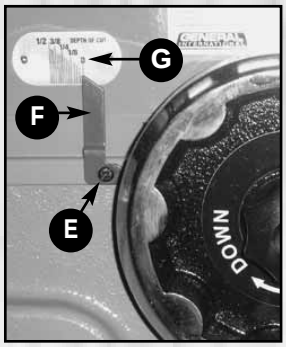
With use and vibration over time, it may eventually become necessary to re-adjust the "Zero point stop bolt" and "Depth of cut indicator" as follows:



1. Set a straightedge onto the in-feed table so that it sits over the cutter head without completely crossing the gap between the tables to touch or sit above the out-feed table **A**.

2. Loosen lock nut **B** and stop bolt **C** located on the underside of the in-feed table.





3. Raise or lower the in-feed table until it is level with the highest point of the cutterhead **D**, then tighten stop bolt **C** and lock nut **B.**

4. If needed, loosen the screw **E** and adjust the pointer **F** left or right until the pointer is set to the zero point on the scale **G**, then re-tighten the screw.

PERIODIC MAINTENANCE

To prolong the service life of your jointer and to maintain optimum performance the following basic maintenance procedures should be practiced and become part of your shop routine.

- Inspect/test the ON/OFF switch before each use. Do not operate the jointer with a damaged switch; replace a damaged switch immediately.
- Keep the machine as well as the in-feed out-feed tables clean and free of saw dust, woodchips, pitch or glue. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the tables' surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners, protectant and dry lubricants based on what is readily available in your area.
- Avoid using silicon based products that may affect or react with wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the planer with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- All bearings are sealed and permanently lubricated and no further lubrication is required. The fence assembly and table ways also should not be lubricated. If you should encounter a "sticking" problem, simply disassemble and clear away any obstructions from the ways.
- Regularly inspect jointed workpieces for signs of knife damage or wear and replace damaged or worn knives immediately.
- Inspect the belt regularly – To avoid potentially costly downtime, consider keeping a spare replacement belt on hand for use if needed. Belts that show visible signs of wear such as cracks or fraying at the edges should be replaced immediately.

RECOMMENDED OPTIONAL ACCESSORIES

We offer a large variety of products to help you increase convenience, productivity, accuracy and safety when using your jointer Here's a small sampling of optional accessories available from your local General International dealer. For more information about our products, please visit our website at www.general.ca

Electronic Earmuffs
 # 99-200
Highly efficient noise reduction to help protect your hearing when operating power tools.

DUST COLLECTORS

Dust collectors contribute to a cleaner more healthful workshop environment.

We offer a wide selection of top quality dust collectors to suit all your shop needs.

Replacement inserts (for MAGNUM Helical cutter head - 200H - 4 rows, total: 22 inserts):
#30-433

DIAGRAM 1

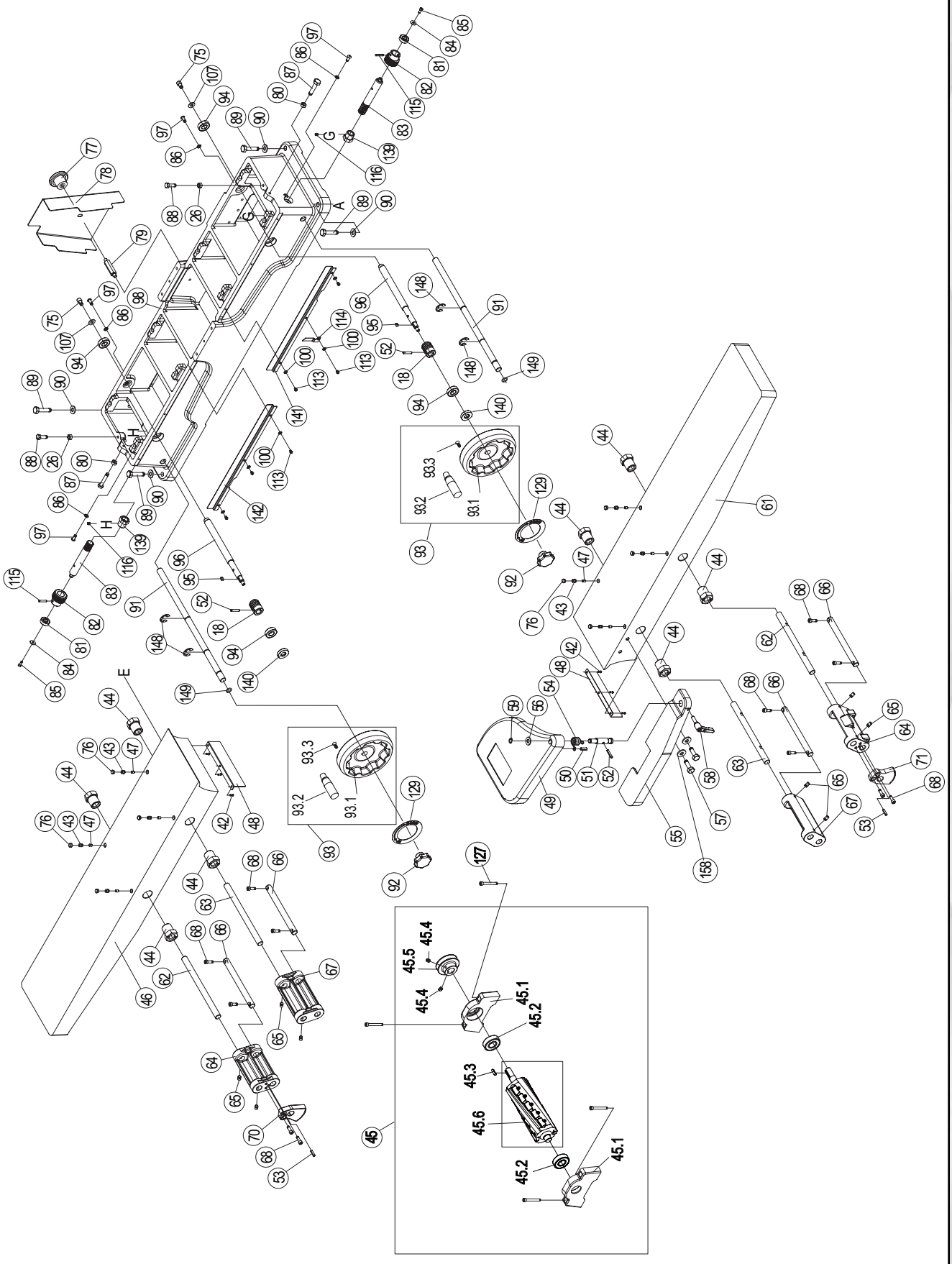
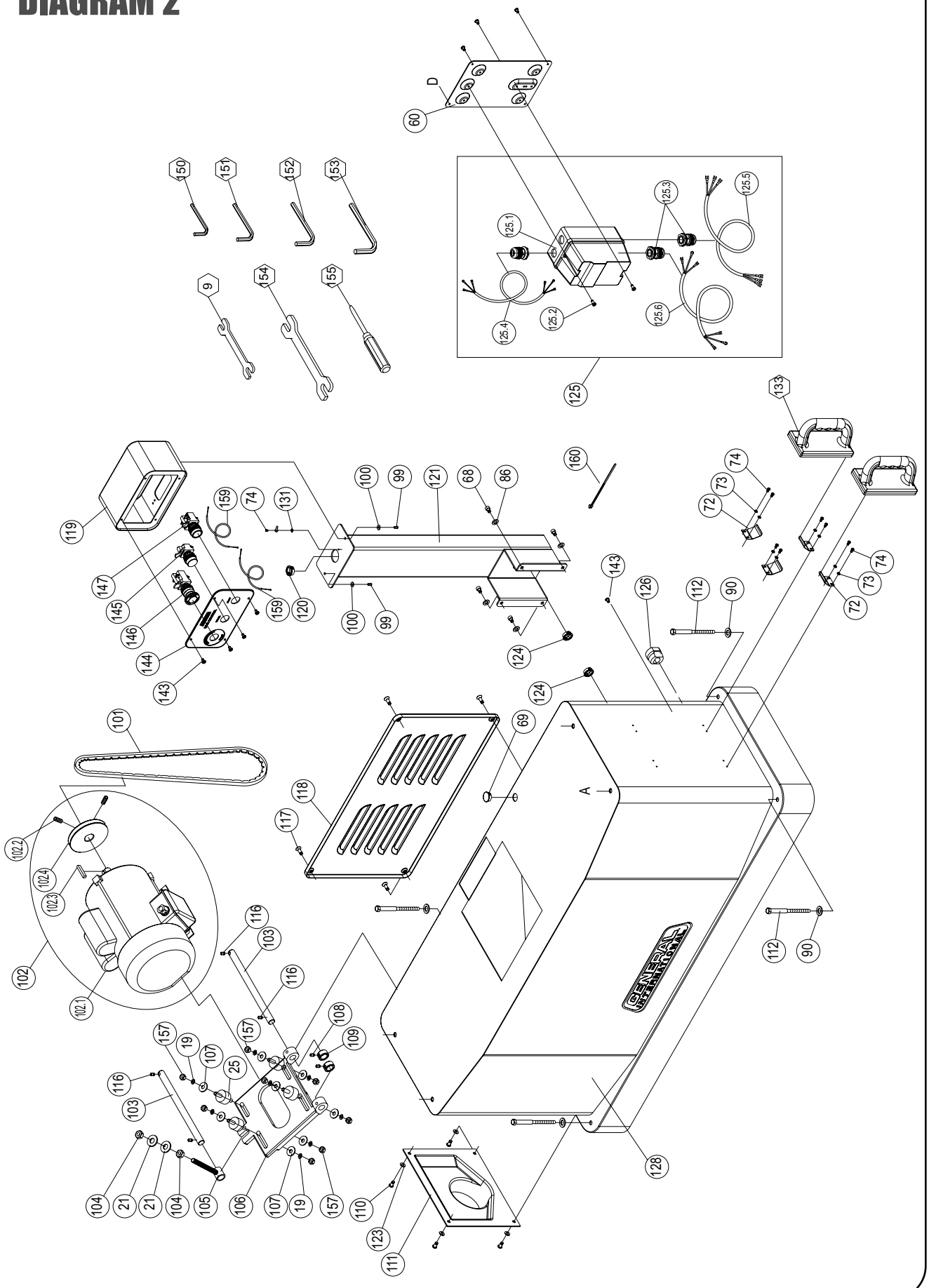
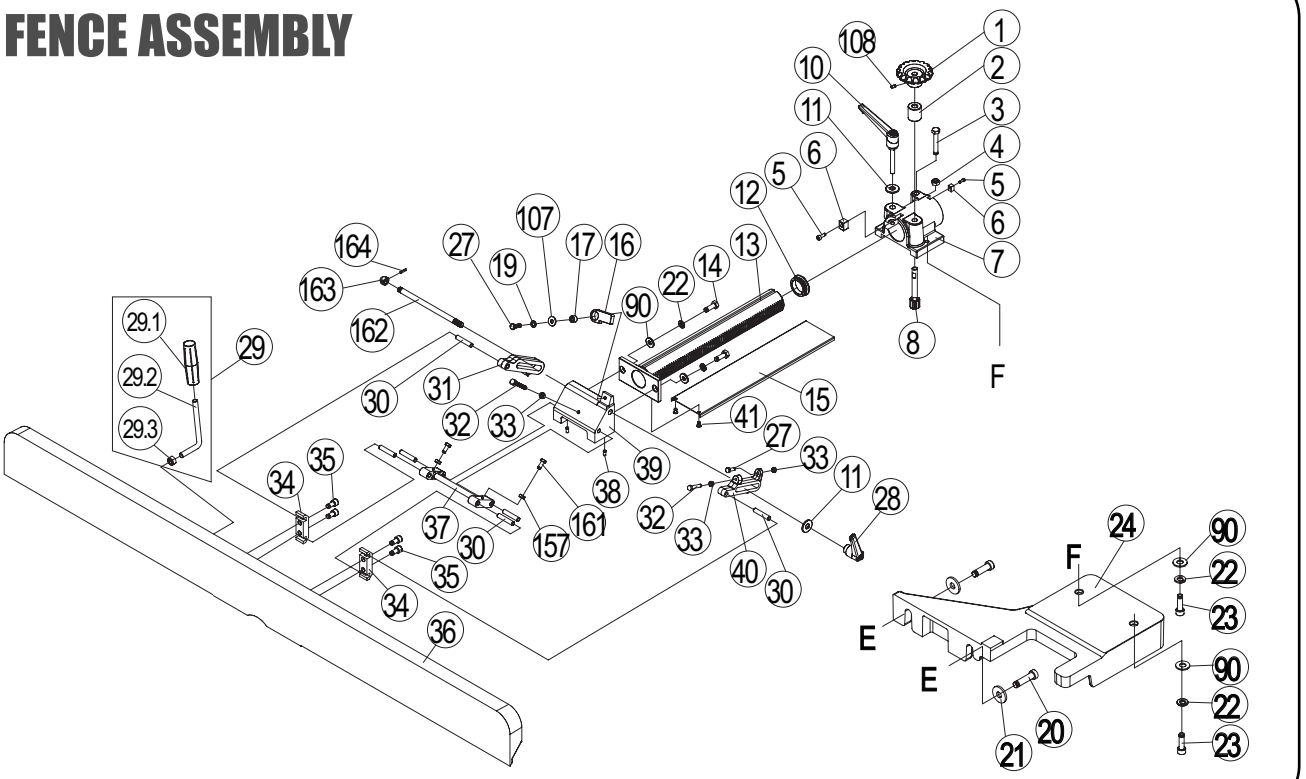


DIAGRAM 2



FENCE ASSEMBLY



PARTS LIST
80-225HC

REF. N0.	PART N0.	DESCRIPTION	SPECIFICATION	QTY
1	80225-01	HANDWHEEL		1
2	80225-02	SPACER		1
3	80225-03	CAP SCREW	M10 X 1.5P X 65	1
4	80225-04	NUT	M10 X 1.5P (17B X 8H)	1
5	80225-05	CAP SCREW	M4 X 0.7P X 12	2
6	80225-06	KEY		2
7	80225-07	COLUMN HOLDER		1
8	80225-08	GEAR SHAFT		1
9	80225-09	OPEN WRENCH	11 – 13	1
10	80225-10	LOCKING HANDLE		1
11	80225-11	FLAT WASHER	13 X 28 X 3.0t	2
12	80225-12	RUBBER COVER		1
13	80225-13	COLUMN		1
14	80225-14	HEX. HEAD BOLT	M10 X 1.5P X 30	2
15	80225-15	STEEL PLATE		1
16	80225-16	STOPPER		1
17	80225-17	BUSHING		1
18	80225-18	WORM GEAR		2
19	80225-19	LOCK WASHER	8.2 X 15.4	9
20	80225-20	CAP SCREW	3/8"-16NC X 1-1/4"	2
21	80225-21	FLAT WASHER	10.2 X 25 X 4.0t	4
22	80225-22	LOCK WASHER	10.2 X 18.5	4
23	80225-23	CAP SCREW	M10 X 1.5P X 30	2
24	80225-24	BRACKET		1
25	80225-25	VIBRATION DAMPENER		4
26	80225-26	NUT	5/16"-18NC (12.7B X 6.75H)	2
27	80225-27	HEX. HEAD BOLT	M8 X 1.25P X 25	2

PARTS LIST 80-225HC

REF. N0.	PART N0.	DESCRIPTION	SPECIFICATION	QTY
28	80225-28	FENCE LOCKING HANDLE		1
29	80225-29	FENCE HANDLE ASSEMBLY		1
29.1	80225-29-1	PLASTIC HANDLE		1
29.2	80225-29-2	BOLT		1
29.3	80225-29-3	NUT	M12 X 1.75P(19B X 10H)	1
30	80225-30	PIVOT CENTER		6
31	80225-31	LEFT LINKAGE		1
32	80225-32	HEX. HEAD BOLT	M8 X 1.25P X 45	2
33	80225-33	HEX. NUT	M8 X 1.25P (13B X 6.5H)	3
34	80225-34	CENTER SEAT		2
35	80225-35	CAP SCREW	M10 X 1.5P X 20	4
36	80225-36	FENCE BODY		1
37	80225-37	LINKAGE		1
38	80225-38	SET SCREW	M6 X 1.0P X 16	2
39	80225-39	LINK BLOCK		1
40	80225-40	RIGHT LINKAGE		1
41	80225-41	BUTTON HEAD SOCKET SCREW	M6 X 1.0P X 10	2
42	80225-42	PAN HEAD PHILLIPS SCREW	1/4"-20NC X 3/8"	6
43	80225-43	SET SCREW	5/16"-18NC X 1/2"	8
44	80225-44	ECCENTRIC ADJUSTER		8
45	80225-45	HELICAL CUTTER HEAD ASSEMBLY (SEE #200H)		1
45.1	80225-45-1	BEARING SEAT		2
45.2	80225-45-2	BEARING	6204-2NSE	2
45.3	80225-45-3	KEY	5 X 5 X 22	1
45.4	80225-45-4	SET SCREW	5/16"-18NC X 3/8"	2
45.5	80225-45-5	CUTTER HEAD PULLEY		1
45.6	80225-45-6	CUTTER HEAD		1
46	80225-46	OUT-FEED TABLE		1
47	80225-47	BRASS STUD		8
48	80225-48	CHIP DEFLECTOR		2
49	80225-49	CUTTER HEAD GUARD		1
50	80225-50	SPRING PIN	6 X 20	1
51	80225-51	PIVOT SHAFT		1
52	80225-52	SPRING PIN	5 X 28	3
53	80225-53	SPRING PIN	5 X 20	2
54	80225-54	SPRING		1
55	80225-55	RABBETING ARM		1
56	80225-56	FLAT WASHER	12 X 20 X 0.8T	1
57	80225-57	HEX. HEAD BOLT	3/8"-16NC X 1-1/4"	2
58	80225-58	LOCKING HANDLE		1
59	80225-59	C-RING	STW-11	1
60	80225-60	SWITCH PLATE		1
61	80225-61	IN-FEED TABLE		1
62	80225-62	PIVOT SHAFT		2
63	80225-63	PIVOT SHAFT		2
64	80225-64	LINKAGE		2
65	80225-65	SET SCREW	5/16"-18NC X 1/2"	8
66	80225-66	PIVOT SHAFT		4
67	80225-67	LINKAGE		2
68	80225-68	CAP SCREW	1/4"-20NC X 3/4"	16
69	80225-69	PLUG	D19	1
70	80225-70	LEFT GEAR PLATE		1
71	80225-71	RIGHT GEAR PLATE		1
72	80225-72	SPRING PLATE		4
73	80225-73	LOCK WASHER	4.1 X 7.7	8
74	80225-74	PHILLIPS HEAD SCREW	M4 X 0.7P X 8	9
75	80225-75	CAP SCREW	5/16"-18NC X 1/2"	2
76	80225-76	PLASTIC CAP		8
77	80225-77	PULLEY COVER KNOB		1

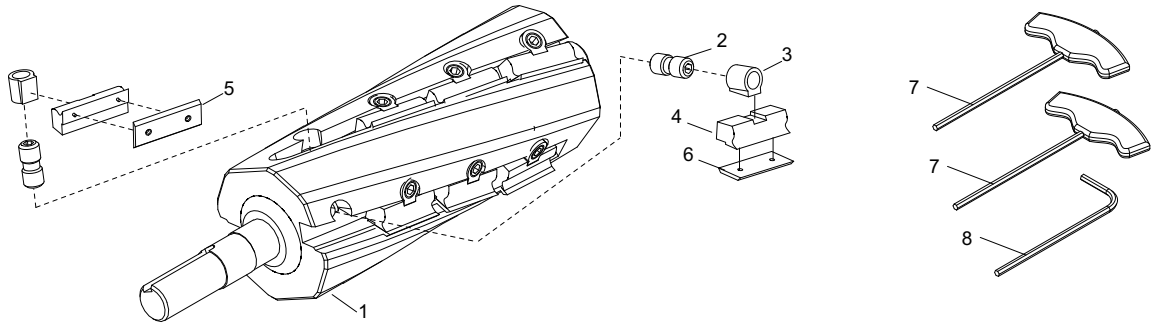
PARTS LIST 80-225HC

REF. N0.	PART N0.	DESCRIPTION	SPECIFICATION	QTY
78	80225-78	PULLEY COVER		1
79	80225-79	GUARD STUD		1
80	80225-80	NUT	1/2"-12NC (19.05B X 11.11H)	2
81	80225-81	BEARING	6000ZZ	2
82	80225-82	WORM GEAR		2
83	80225-83	SHAFT		2
84	80225-84	FLAT WASHER	5.3 X 16 X 1.5T	2
85	80225-85	CAP SCREW	3/16"-24NC X 1/2"	2
86	80225-86	FLAT WASHER	6.4 X 11.5 X 1.6T	8
87	80225-87	HEX. HEAD BOLT	1/2"-12NC X 2"	2
88	80225-88	HEX. HEAD BOLT	5/16"-18NC X 1"	2
89	80225-89	HEX. HEAD BOLT	3/8"-16NC X 1-3/4"	4
90	80225-90	FLAT WASHER	10.3 X 22 X 2.0T	12
91	80225-91	LIFTING BAR		2
92	80225-92	KNOB		2
93	80225-93	HANDWHEEL ASSEMBLY		2
93.1	80225-93-1	HANDWHEEL		1
93.2	80225-93-2	FOLDING HANDLE		1
93.3	80225-93-3	FLAT HEAD SCREW	M6 X 1.0P X 12	1
94	80225-94	BEARING	6002ZZ	4
95	80225-95	KEY	5 X 5 X 10	2
96	80225-96	SHAFT		2
97	80225-97	PHILLIPS SCREW	1/4"-20NC X 5/8"	4
98	80225-98	BASE		1
99	80225-99	CAP SCREW	M5 X 0.8P X 8	2
100	80225-100	FLAT WASHER	5.2 X 10 X 1.0T	8
101	80225-101	V BELT	A50	1
102	80225-102	MOTOR ASSEMBLY	3HP X 220V X 60HZ X 1PH X 2P	1
102.1	80225-102-1	MOTOR	3HP X 220-240V X 60HZ X 1PH X 2P X 13A	1
102.2	80225-102-2	SET SCREW	1/4"-20NC X 1/4"	2
102.3	80225-102-3	KEY	5 X 5 X 22	1
102.4	80225-102-4	MOTOR PULLEY		1
103	80225-103	ROUND BAR		2
104	80225-104	NUT	M10 X 1.25P (17B X 8H)	2
105	80225-105	ADJUSTING SCREW		1
106	80225-106	BASE PLATE		1
107	80225-107	FLAT WASHER	8.5 X 23 X 2.0T	11
108	80225-108	SET SCREW	M6 X 1.0P X 8	3
109	80225-109	COLLAR		2
110	80225-110	PHILLIPS SCREW	1/4"-20NC X 1/2"	4
111	80225-111	DUST PORT		1
112	80225-112	BOLT	3/8"-16NC X 6"	4
113	80225-113	PHILLIPS HEAD SCREW	3/16"-24NC X 1/4"	6
114	80225-114	POINTER		1
115	80225-115	SPRING PIN	4 X 25	2
116	80225-116	SET SCREW	1/4"-20NC X 1/4"	6
117	80225-117	FLAT HEAD SCREW	1/4"-20NC X 3/4"	4
118	80225-118	ACCESS PANEL		1
119	80225-119	CONTROL BOX		1
120	80225-120	WIRE PROTECTOR	NB-2430	1
121	80225-121	SWITCH POST		1
123	80225-123	FLAT WASHER	6.6 X 13 X 1.0T	4
124	80225-124	WIRE PROTECTOR	NB-1722	2
125	80225-125	MAGNETIC SWITCH ASSEMBLY	3HP X 220-240V X 1PH	1
125.1	80225-125-1	MAGNETIC SWITCH	3HP X 220V~240V X 1PH	1
125.2	80225-125-2	PHILLIPS HEAD SCREW	M5 X 0.8P X 15	2
125.3	80225-125-3	WIRE PROTECTOR	1/2"	3
125.4	80225-125-4	MESSAGE WIRE	VCTF 0.75MM X 5C X 1250MM	1

PARTS LIST 80-225HC

REF. NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
125.5	80225-125-5	MOTOR WIRE	SJT12AWG X 3C X 850MM	1
125.6	80225-125-6	POWER CORD	SJT12AWG X 3C X 2400MM	1
126	80225-126	STRAIN RELIEF	SB8R-1	1
127	80225-127	CAP SCREW	5/16"-18NC X 2"	4
128	80225-128	CABINET		1
129	80225-129	DIRECTION STICKER		1
131	80225-131	EXTERNAL SPROCKET WASHER	4.3 X 8.5 (BW-4)	1
133	80225-133	PUSH BLOCK		2
139	80225-139	SPACER		2
140	80225-140	SPACER		2
141	80225-141	RIGHT PLATE		1
142	80225-142	LEFT PLATE		1
143	80225-143	PHILLIPS HEAD SCREW	M5 X 0.8P X 8	8
144	80225-144	CONTROL BOARD	GENERAL	1
145	80225-145	INDICATOR LIGHT	25 X 250V X 1.2W	1
146	80225-146	STOP BUTTON		1
147	80225-147	START BUTTON		1
148	80225-148	E RETAINER	ETW-15	4
149	80225-149	O RING	P12	2
150	80225-150	ALLEN KEY	4 MM	1
151	80225-151	ALLEN KEY	5 MM	1
152	80225-152	ALLEN KEY	6 MM	1
153	80225-153	ALLEN KEY	8 MM	1
154	80225-154	OPEN WRENCH	17- 19 MM	1
155	80225-155	SCREW DRIVER		1
157	80225-157	NUT	M8 X 1.25P (13B X 6.5H)	10
158	80225-158	FLAT WASHER	10 X 20 X 3.0T	2
159	80225-159	WIRE	SJT18AWG X 1C X 85MM	2
160	80225-160	TIE WRAP	ALC-110S	1
161	80225-161	HEX. HEAD BOLT	M8 X 1.25P X 20	2
162	80225-162	BOLT		1
163	80225-163	CAP NUT	M12 X 1.75P	1
164	80225-164	SPRING PIN	4 X 18	1

HELICAL CUTTER HEAD - 200H



REF NO.	PART NO.	DESCRIPTION	SPECIFICATION	QTY
1	200H-01	CUTTER HEAD		1
2	200H-02	SCREW		22
3	200H-03	NUT		22
4	200H-04	KNIFE-HOLDER / CHIP-BREAKER		22
5	30-443	CARBIDE INSERT (STANDARD)	30X12X1.5MM (T)	22
6	200H-06	CARBIDE INSERT (RABBETING)	30X12X1.5MM (T)	2
7	200H-07	T HANDLE ALLEN KEY	5MM	2
8	200H-08	ALLEN KEY	5MM	1

Notes

MODEL 80-225HC

8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3

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IMPORTANT

When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.